

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.15**SOURCE INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-000692**Date Inspected:** 26-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 0**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 12**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Dao, Shanghai

Quality Control Contact:	ABF Paint Supervisor William (Bill) Oak			Quality Control Present:	Yes	No
Material transfer:	Yes	No	N/A	Sampled Items:	Yes	No N/A
Stock Transfer:	Yes	No	N/A	OK to Cut:	Yes	No N/A
Rebar Test Witness:	Yes	No	N/A	Delayed/Cancelled:	Yes	No N/A

Other: Surface Preparation and Coatings Application**Bridge No:** 34-0006**Component:** OBG L2W, 1AAW, Misc. Metal, Tower L2S**Bid Item:** 77,78,79,80**Lot No:** B226**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) NACE III coating inspector, Mr. Donald Jordan arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China. The purpose of the coating inspections are to monitor the surface preparation and coating applications for the SAS Bay Bridge project. This QA NACE III coating inspector observed the following:

The following inspections were performed by Caltrans QA Coatings Inspector Jordan, American Bridge/Fluor Enterprises, a JV (ABF) Paint Supervisors William (Bill) Oak and Don Walton, ABF QC Zhou Qun Song (Joe), ABF QC David Duon, ABF QC Shi Zhaoyuan (Stone), ABF QC Zhou Wei, ABF QC Wei Chang Yun, ABF QC Sun Xiong, International Paint (IP) Onsite Technical Services Engineer (OTSE) Peng Zi Li, IP OTSE Alpha Chen, Zhenhua Port Machinery Company, LTD (ZPMC) QC Manager Xia Yong, ZPMC QC Zhang Diang, ZPMC QC Dong Yao Fei and ZPMC QC Guo Wan Li, ZPMC QC Xie Yong Gang, ZPMC QC An Ming, ZPMC QC Dong Ji Fang and ZPMC QC Xia Yu Juan.

All Notices of Inspection and Quality Control (QC) Inspection reports signed by Mr. Jordan on this date identify receipt of the documentation and are not intended to be identified as acceptance or rejection of the work performed.

Tower Lift 2 South

Caltrans QA Coatings Inspectors received a Notice of Inspection for to attend a joint inspection with ABF and ZPMC QC to locate visual surface anomalies and weld defects on the internal section of Tower Lift 2 South from 65m to 85m. ABF verbally requested that the Caltrans welding staff be notified to perform VT inspection after

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blast. Areas requiring grinding were identified and marked by QC and QA staff. Caltrans QA Weld Inspector's performed VT inspection to locate and mark any weld repairs required. The weld repair spots were identified by placing tape over the area so it can be located after primer application. After the inspection was complete, grinding was performed to remove base metal defects. Abrasive blasting resumed after grinding was completed. NO ZPMC or ABF steel inspectors were on site looking at the welds.

OBG 1AAW

Caltrans QA Coatings Inspectors received Notices of Inspection to attend joint inspections with ABF and ZPMC QC for surface preparation by abrasive blasting and primer coat application on the internal bottom portion of OBG 1AAW. After the inspection was completed the surfaces were determined to successfully meet the SSPC SP10 Near White Metal Contract requirements. Residual Chlorides (soluble salts) tests were performed on the abrasive blasted surfaces. The Bresel Patch method was used to test for Residual Chlorides. The test results showed that the surface was acceptable to be coated with Interzinc 22. The highest registered reading of salts contamination was 10 microsiemens per square centimeter which is below the contract maximum of 10 micrograms per square centimeter (92.5 microsiemens per square centimeter). Ambient conditions were within Contract required parameters. Surface profile Testex Tape was used by ZPMC QC personnel to record the blast profile. The Testex tape was measured using a dial micrometer. The micrometer readings of the Testex Tape were within the contract requirements of 40 and 86 microns. Ambient conditions were within Contract required parameters. The surfaces to be coated were blown down again with compressed air to remove dust. After the dust was removed, Interzinc 22 primer was applied within the specified 8 hour window after the start of abrasive blasting. The coating was mixed under the supervision of International Paint's Onsite Technical Services Representative, QC personnel representing ABF and ZPMC.

OBG Miscellaneous Metal

Caltrans QA Coatings Inspectors received Notices of Inspection to attend joint inspections with ABF and ZPMC QC for surface preparation by abrasive blasting and primer coat application on 4 counterweight segments and 1 suspender bracket. Abrasive blasting was still in progress when the inspectors arrived. After a while the inspection was canceled by ZPMC. The inspection will be re-scheduled after the work is completed.

OBG Lift 2 West

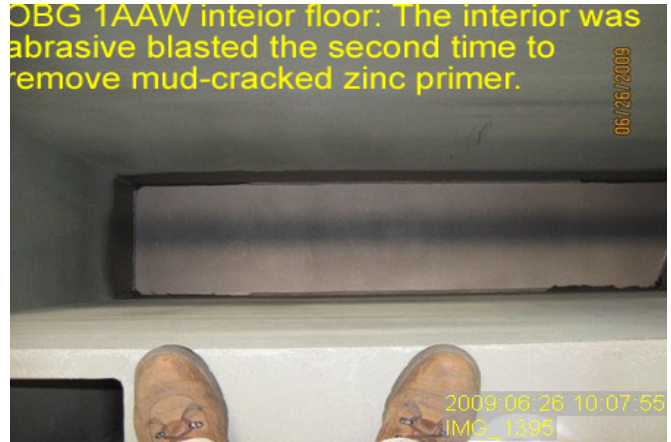
Caltrans QA Coatings Inspectors received Notices of Inspection to attend joint inspections with ABF and ZPMC QC for surface preparation by abrasive blasting and primer coat application on the internal and external weld seam joint of OBG L2W. After the inspection was completed the surfaces were determined to successfully meet the SSPC SP10 Near White Metal Contract requirements. Residual Chlorides (soluble salts) tests were performed on the abrasive blasted surfaces. The Bresel Patch method was used to test for Residual Chlorides. The test results showed that the surface was acceptable to be coated with Interzinc 22. The highest registered reading of salts contamination was 10 microsiemens per square centimeter which is below the contract maximum of 10 micrograms per square centimeter (92.5 microsiemens per square centimeter). Ambient conditions were within Contract required parameters. Surface profile Testex Tape was used by ZPMC QC personnel to record the blast profile. The Testex tape was measured using a dial micrometer. The micrometer readings of the Testex Tape were within the contract requirements of 40 and 86 microns. Ambient conditions were within Contract required parameters. The surfaces to be coated were blown down again with compressed air to remove dust. After the dust was removed, Interzinc 22 primer was applied within the specified 8 hour window after the start of abrasive blasting. The coating was mixed under the supervision of International Paint's Onsite Technical Services

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Representative, QC personnel representing ABF and ZPMC.

Fabrication on assembled components of the OBG's and Towers are not complete. Outstanding weld repairs have not been performed. Coating damage requiring re-blast is expected.



Summary of Conversations:

There were no relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh (China) +8613472477571, who represents the Office of Structural Materials for your project.

Inspected By:	Jordan,Don	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
